

Work Order ID 72900

Wednesday, August 17, 2011 2:47:44 PM



Page 1

Item ID: D4278-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Rib Assembly-Straight

Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 8-17-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4277

D

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 117584

0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut tube as per dwg D4277
- 2- Drill and chamfer holes on both side using DT9715
- 3- Remove marking
- 4-Debur
- 5- Assemble bushing and weld as per dwg
- 6- Grind weld flush as per dwg

110

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8-16-11/23

XC

Pl 11-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72900

Wednesday, August 17, 2011 2:47:44 PM



Page 2

Item ID: D4278-047

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Start Date: 8/17/2011 Start Qty: 1.00



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Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

0.00 5 462/23

(2)

130

Identify as per dwg & Stock Location: B/c

0.00



Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

Pl 11-08-23

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24

11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:47:49 PM

Page 1

Work Order ID: 72900

Parent Item: D4278-047

Parent Item Name: Upper Rib Assembly-Straight



Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

f

386.2431

2.189474



304 SQ Tube .75x.75x.049W



Cpl 11-08-22

Location

Loc Qty

Loc Code

MAT018

285.487909

117690

4.372109

117775

98.4265

118472

182.6893

MAT034

1.8507

117337

1.8507

WA

98.90454

118184

98.90454

D4021-9

Manufactured

No

100

Each

126.0000

4

4



Bushing



Cpl 11-08-22

Location

Loc Qty

Loc Code

WA

124

70333

60

72482

64

WA005

2

66437

2

4

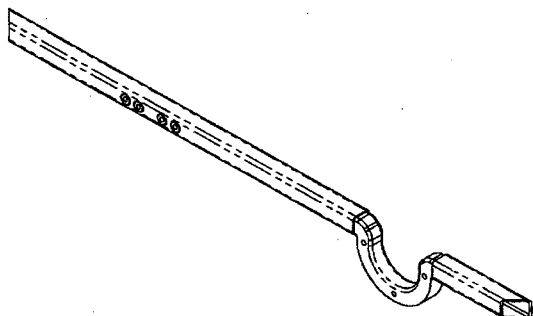
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

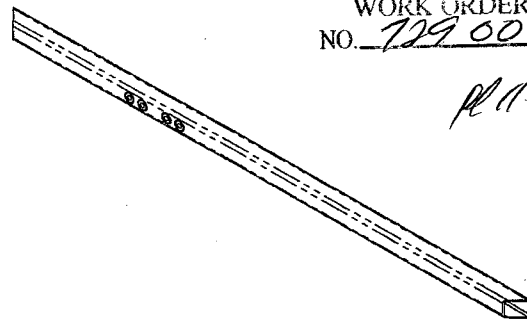
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



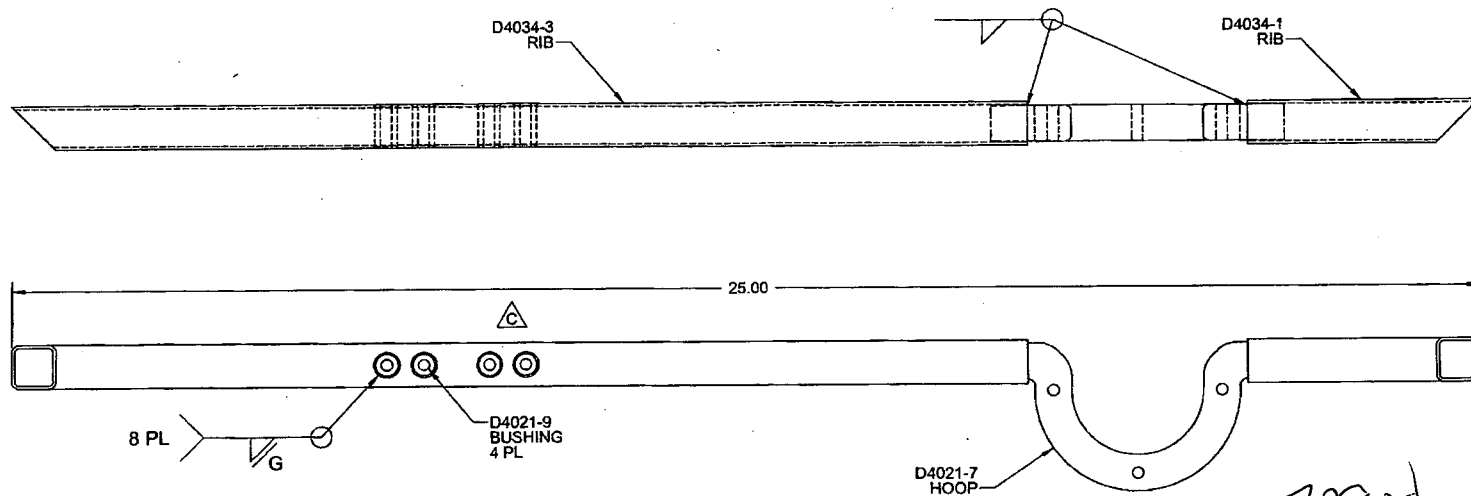
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 729 00

11-08-17

RELEASED
R 2011-01-18
MP

REV.	DESCRIPTION	BY	DATE
C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4278	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

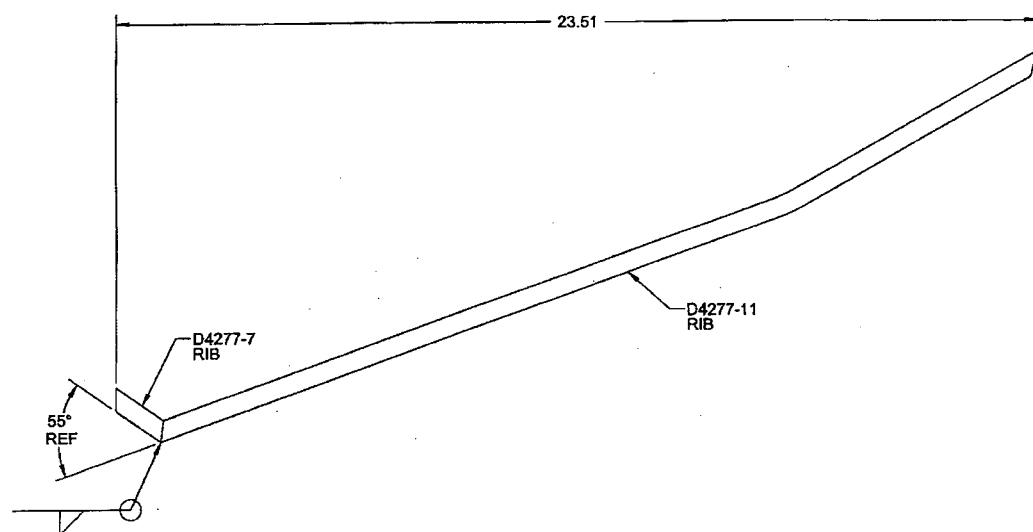
RELEASED
2011-01-18

NOTES:

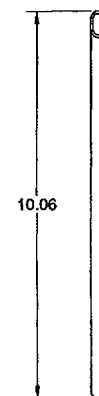
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 2 OF 4
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ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM



72902

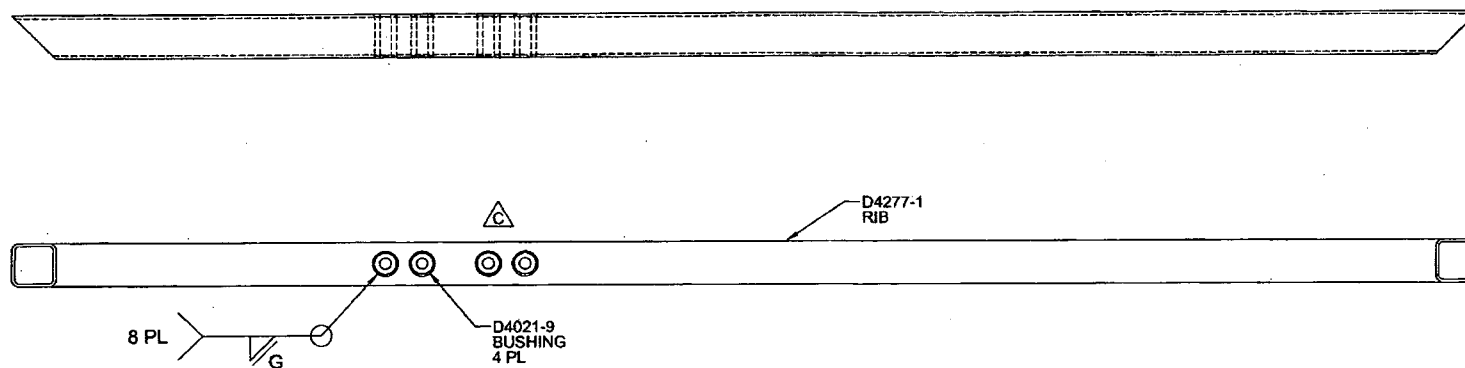
RELEASED
2011-01-18
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

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MFG APPR.		D4278	SHEET 3 OF 4
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DE APPR.		RIB ASSEMBLY	NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

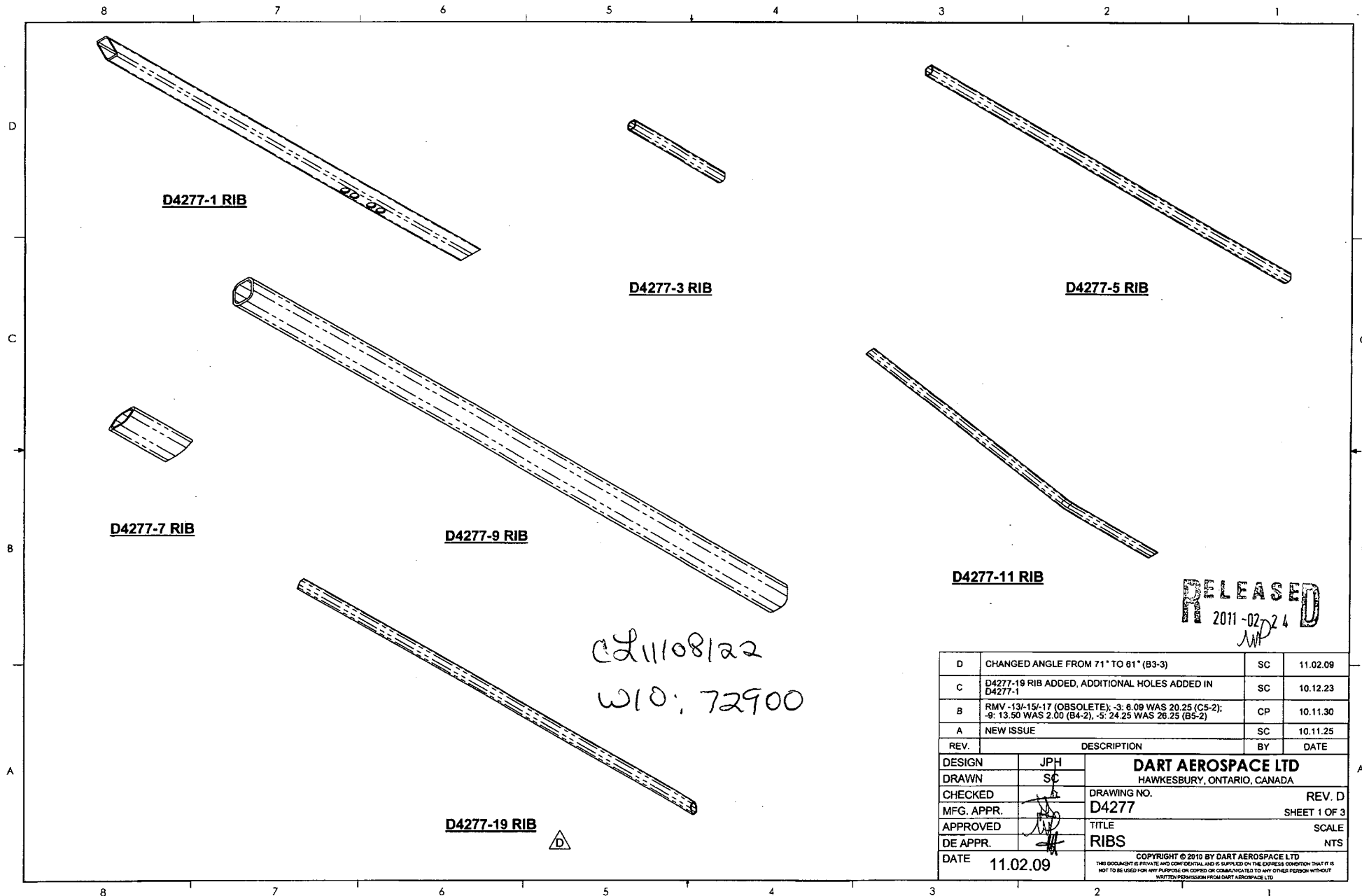
72900

RELEASED
2011-01-18
MAD

NOTES:

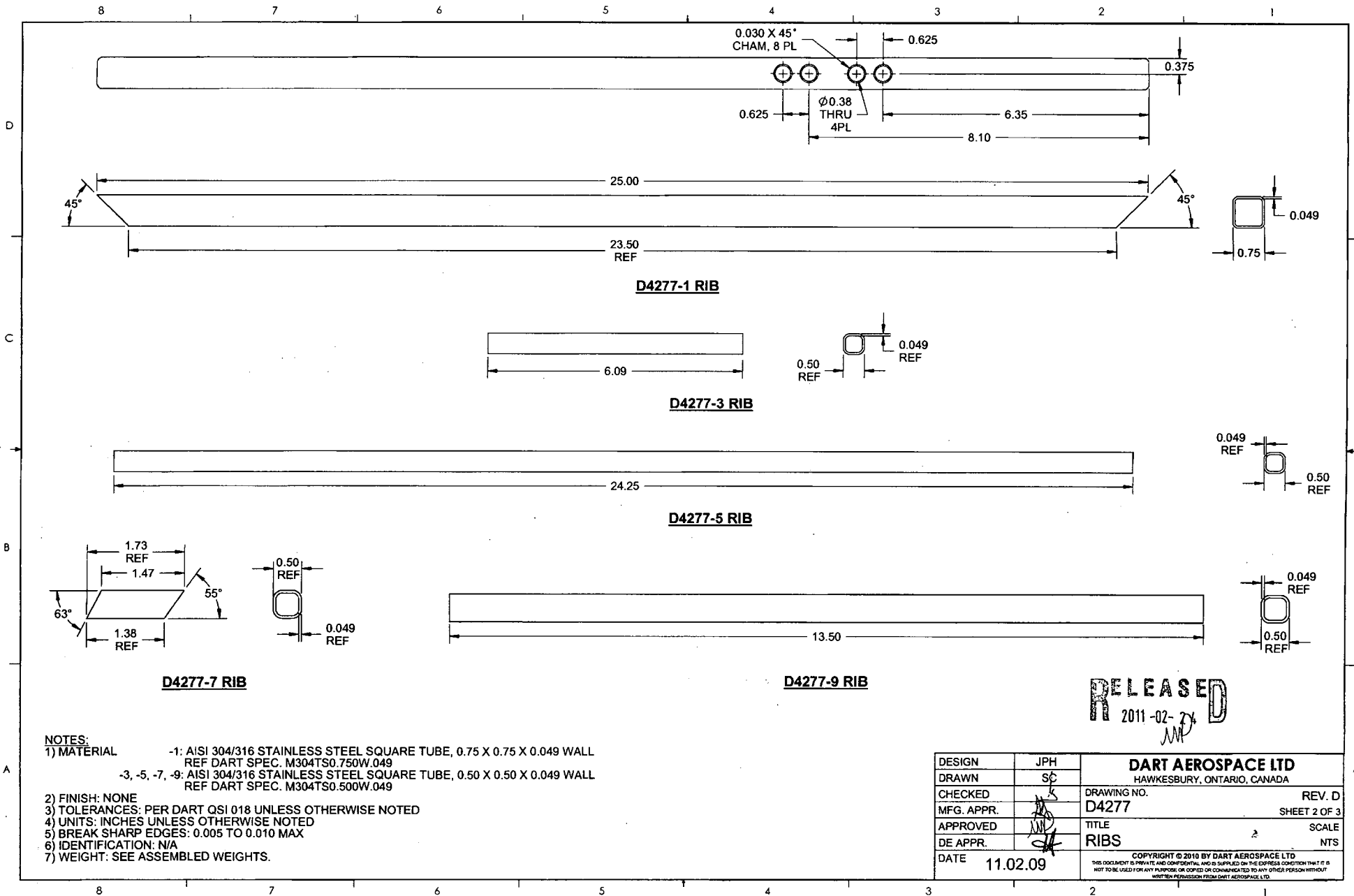
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

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APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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RELEASED
2011-02-24
MP

D	CHANGED ANGLE FROM 71° TO 81° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -8: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4277 TITLE RIBS SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	11.02.09	REV. D SHEET 1 OF 3	

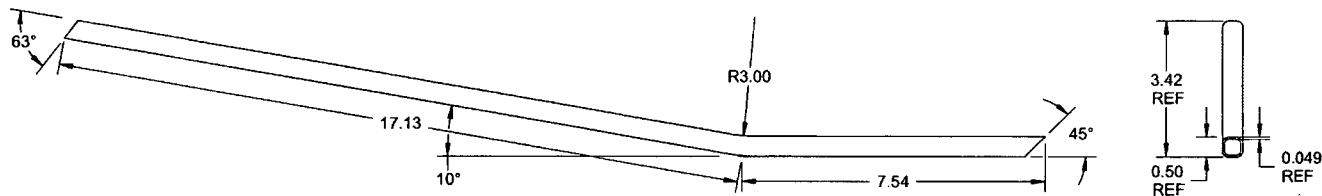


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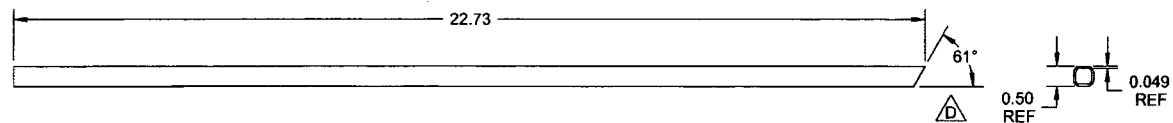
- 1) MATERIAL
 -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
 REF DART SPEC. M304TS0.750W.049
 -3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
 REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

RELEASED
 2011-02-24

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	K	DRAWING NO. D4277	REV. D
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIBS	SCALE NTS
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DATE	11.02.09		



D4277-11 RIB



D4277-19 RIB

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

RELEASED
2011-02-24

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 3 OF 3
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